

Work Order ID 71050

Tuesday, June 21, 2011 1:29:33 PM

Page 1

Item ID: D206-642-441

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 6/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 6/21/11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod M112860 / M117456 BE 11/06/28

4-Grind weld flush to cap on top surface only. BE 11/06/28

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

11/06/29

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u l o 6 / 3 0

116



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S u l o 6 / 3 0

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

S A P 11-06 30

1 0

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP 11-6-30

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐Start Date: 11/06/30 ☐Time: ☐ 2:00 pm☐Finish Date: 11/07/05 ☐Time: ☐ 11:00A/R ☐ Sikaflex-291 ☐ M 116945 ☐Sikaflex expiry date: ☐ 12/01/15

Wb
11/06/30

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1 0 BE 11/07/05

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod M112860

2-Grind welds flush as per Dwg D2650.

Wk 11/07/05

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 11/07/05

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

1 0 BEUP7/06

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8 16/7/07

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 16/7/07FXU

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 ϕ BT 11-7-11.

205

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117314
DEFLEET BLUE B 118395
DEFLEET CLEAR B 117984

BT 11-07-20

225

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

M 11 07 21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ 11116085Sikaflex expiry date: ☐ 11108

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ 11116085Sikaflex expiry date: ☐ 11108

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 11117863

1 0 11107126

Dart Aerospace Ltd

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 27 ①

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPP 71049

11/7/28

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/29

11-07-28

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Picklist Print

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7

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Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube







Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	9.0000	1	1		B 11/06/28																
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>LG</td><td>9</td><td></td></tr><tr><td>62684</td><td>1</td><td></td></tr><tr><td>68135</td><td>1</td><td></td></tr><tr><td>68136</td><td>7</td><td></td></tr></table>														Location	Loc Qty	Loc Code	LG	9		62684	1		68135	1		68136	7	
Location	Loc Qty	Loc Code																										
LG	9																											
62684	1																											
68135	1																											
68136	7																											
D2646  Aft Cap		Manufactured	No			110	Each	80.0000	1	1		u 11/07/26																
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>FP004</td><td>62</td><td></td></tr><tr><td>68280</td><td>62</td><td>1371038</td></tr><tr><td>FP006</td><td>18</td><td></td></tr><tr><td>62678</td><td>18</td><td></td></tr></table>														Location	Loc Qty	Loc Code	FP004	62		68280	62	1371038	FP006	18		62678	18	
Location	Loc Qty	Loc Code																										
FP004	62																											
68280	62	1371038																										
FP006	18																											
62678	18																											
D2647  Cap		Manufactured	No			140	Each	25.0000	1	1		B 11/06/28																
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LG002	25																											
55352	25																											
D2654-7  Web		Manufactured	No			160	Each	0.0000	1	1		B 71310 u 11/06/28																

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Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

569.0000

2

2



Cherry Rivet



BE 4/07/06

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

567

117086

71

117849

496

2

D2649

Manufactured

No

170

Each

111.0000

23

23



Cross Bolt Spacer



BE 11/07/05
871355 23

Location

Loc Qty

Loc Code

LG

99

68224

2

70394

97

LG001

12

65317

1

68507

11

D2680-041

Manufactured

No

170

Each

30.0000

1

1



Nut Plate



BE 11/07/06

Location

Loc Qty

Loc Code

ST020

30

55366

17

70088

13

Tuesday, June 21, 2011 1:29:40 PM

Shop Packet Print

Page 2

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Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No

230 Each 1,478.000 60 60



Insert

HL 11/07/26

Location

Loc Qty

Loc Code

ST281

8

M118386

V60

117331

8

ST282

1470

117717

1470

AN960JD10L NAS1149D0332J Purchased No

230 Each 0.0000 2 2



Washer

M117087

(x2) HL 11/07/26

AN960JD416 NAS1149D0463J Purchased No

230 Each 0.0000 1 1



Washer

M116805

(x1) HL 11/07/26

CR3212-4-03 Purchased No

230 Each 1,216.000 2 2



Cherry Rivet

BE 11/07/06

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1214

114859

1214

2

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Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

230

Each

251.0000

22

22



22 11/07/26

Plug

Location

Loc Qty

Loc Code

fpa

109

371037

22

69018

109

FP-A

142

57869

1

66445

10

67760

97

70827

30

70839

4

D2651-3 Manufactured No

230

Each

536.0000

22

22



22 11/07/26

O-Ring

Location

Loc Qty

Loc Code

FP-A

536

61962

104

66956

432

22

D3535-15 Manufactured No

230

Each

27.0000

1

1



1 11/07/26

Wearshoe

Location

Loc Qty

Loc Code

FP018

27

66558

7

68358

6

69931

14

22

Tuesday, June 21, 2011 1:29:40 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:29:40 PM

Work Order ID: 71050



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-23

Manufactured No

230

Each

20.0000

1

1



Handwritten: 11/07/26

Wearshoe

Location

Loc Qty

Loc Code

FP021

20

66236

-1

67594

8

68342

13

Handwritten: X1

D3535-37

Manufactured No

230

Each

3.0000

1

1



Handwritten: 11/07/26

Wearshoe

Location

Loc Qty

Loc Code

FP018

3

1371668

Handwritten: X1

67612

3

D3536-15

Manufactured No

230

Each

17.0000

1

1



Handwritten: 11/07/26

Gasket

Location

Loc Qty

Loc Code

FP011

17

66559

17

Handwritten: X1

D3536-23

Manufactured No

230

Each

39.0000

1

1



Handwritten: 11/07/26

Gasket

Location

Loc Qty

Loc Code

FP011

39

43406

1

66560

12

69902

26

Handwritten: X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:29:41 PM

Work Order ID: 71050

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-37	Manufactured	No	230	Each	16.0000	1	1
							<u>ju 11/07/26</u>

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	16	
63237	4	
66823	12	

D3537-1	Manufactured	No	230	Each	7.0000	6	6
							<u>ju 11/07/26</u>

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	7	B70972
69817	7	

D3537-3	Manufactured	No	230	Each	9.0000	1	1
							<u>ju 11/04/26</u>

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	1	B70981
35697	1	
FP19	8	
69292	8	

MS27039-1-08	Purchased	No	230	Each	744.0000	2	2
							<u>ju 11/07/26</u>

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	744	
115108	444	
117423	300	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:29:41 PM

Work Order ID: 71050

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

230

Each

57.0000

1

1



24 11/07/26

Screw

Location

Loc Qty

Loc Code

FP-A

23

115460

23

ST292

34

115460

34

MS27039C1-08

Purchased

No

230

Each

1,304.000

60

60



24 11/07/26

SCREW

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

1303

116373

3

117291

800

118077

500

24 11/07/26

NAS1149C0332R

Purchased

No

230

Each

1,630.000

60

60



24 11/07/26

Washer

Location

Loc Qty

Loc Code

FP-B

15

117291

15

ST297

1615

116304

55

117460

330

117887

830

118078

400

11118306

24 11/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71650
11-06-21

RELEASED
08-23-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

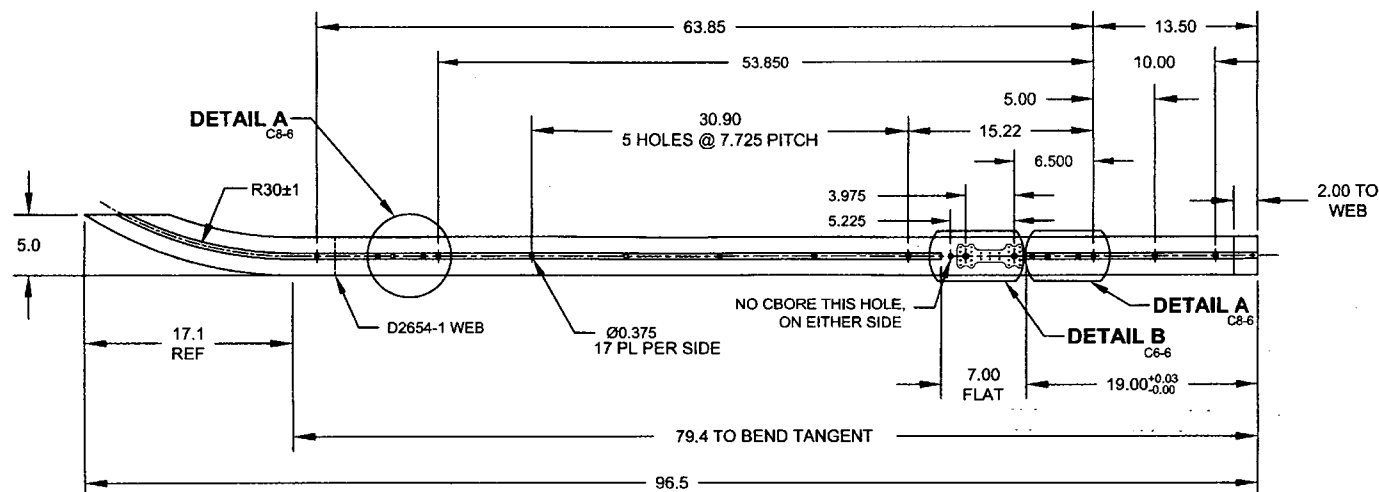
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

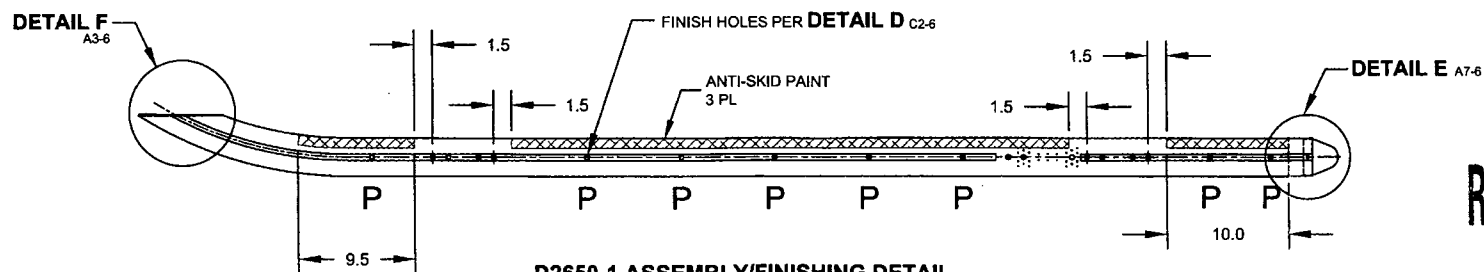
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
880922/114

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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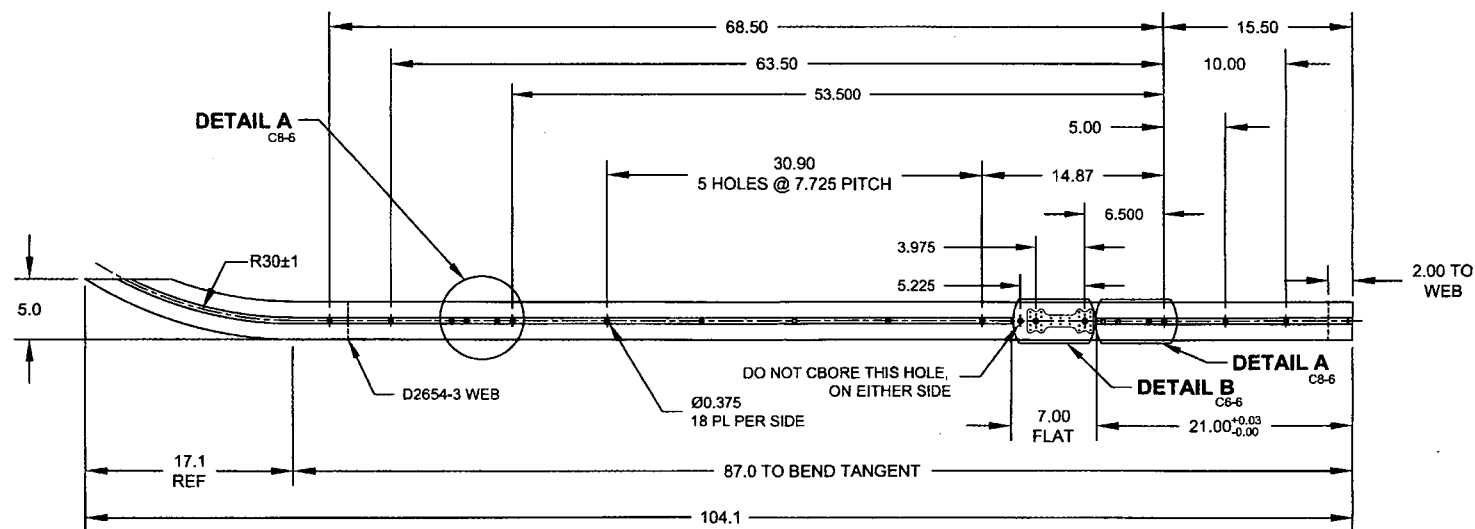
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

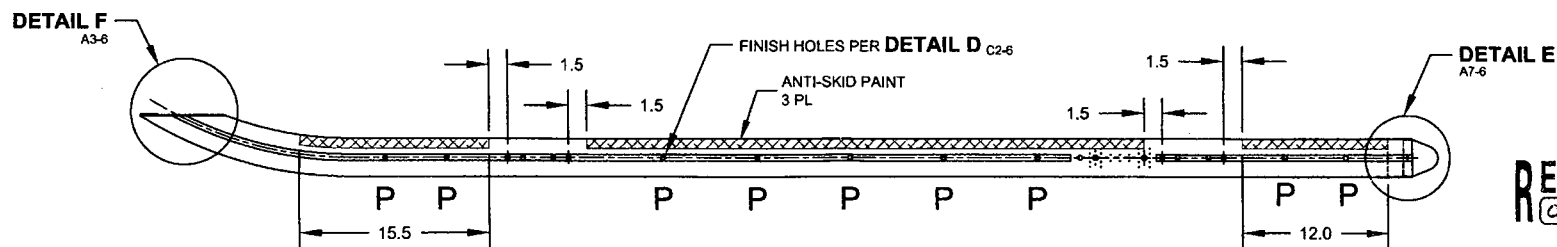
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

71050

RELEASED
08 07 22 118

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

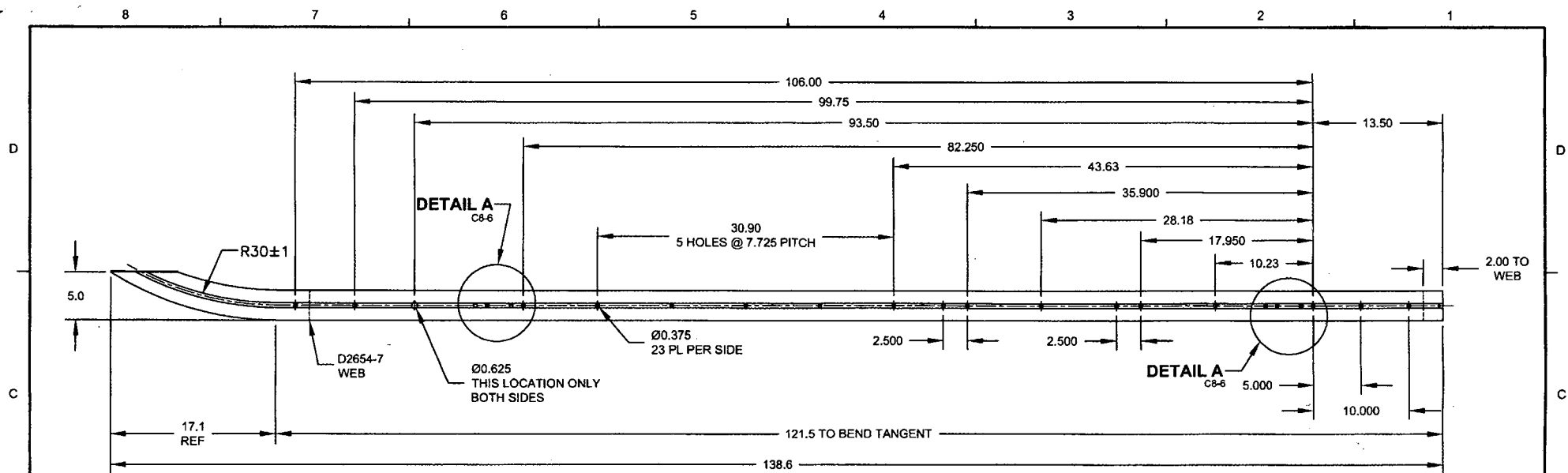
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

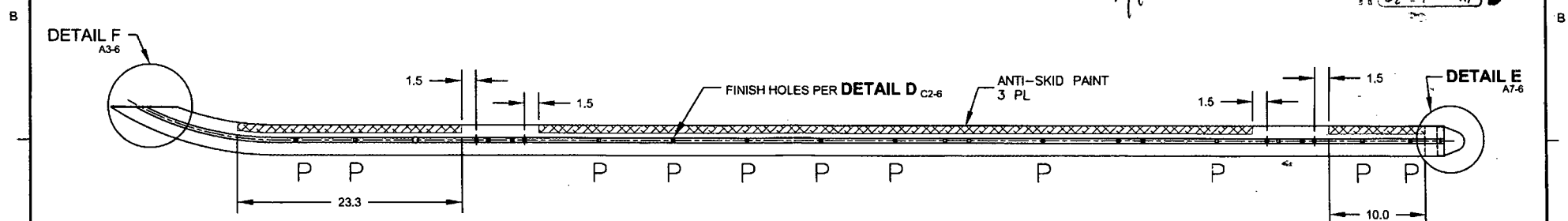
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



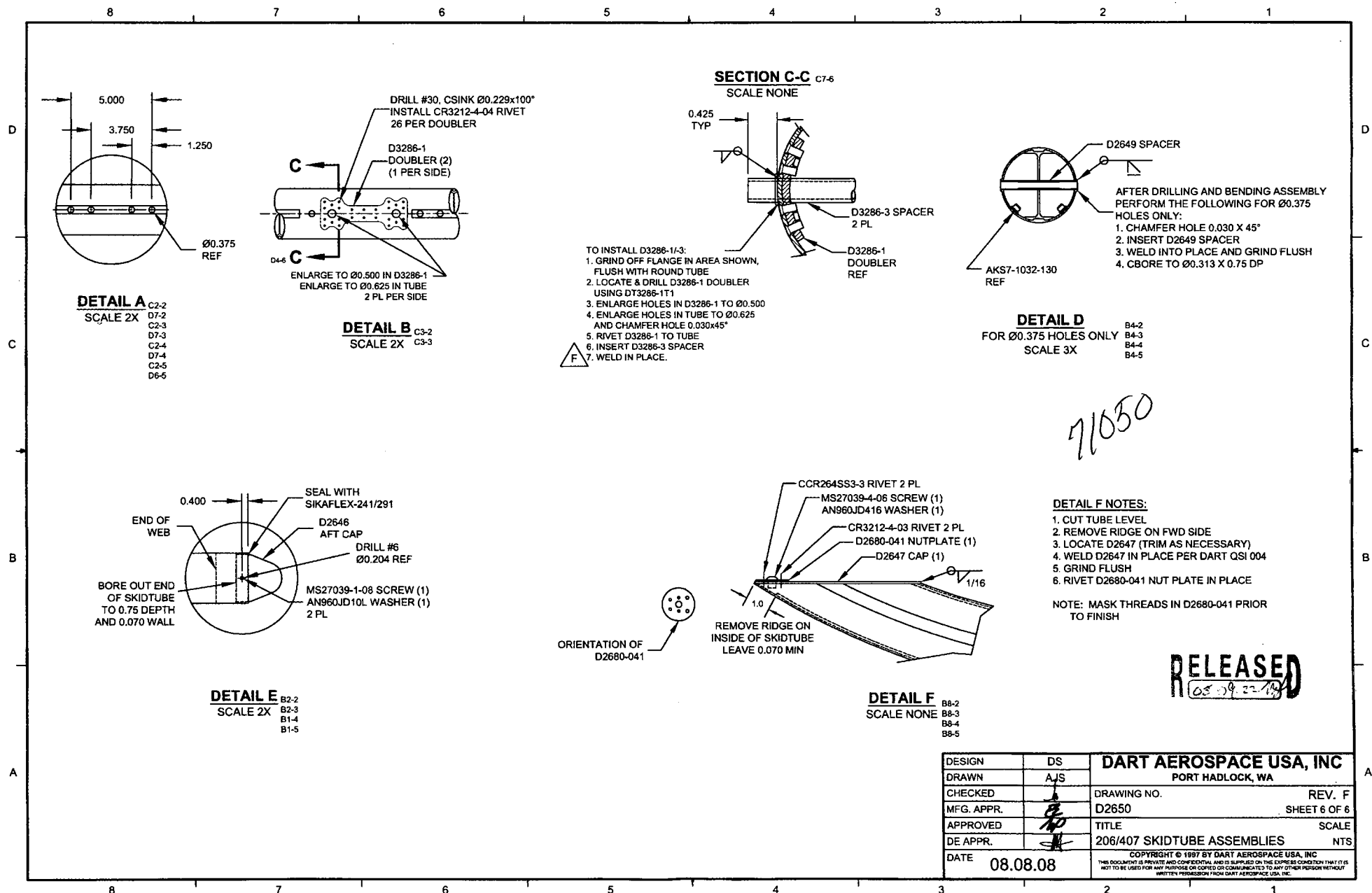
D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
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RELEASED
06 07-22 1111



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

255
NO. ~~255~~

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 69953 69953
Part number: 206 - 642 - 341
Description: 206
Welding Process: Tig ☒ Mig ☐
Base material: _____
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Lat Cunn Date of Test Coupon 11.06.14
Welder Barclay Elliot Date of Test Coupon 11/06/14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld